



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4712-1
Job Sheet 185097



Part No: D4712-1

Job Qty: 10 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,3 IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	10 pcs		11/16/18	0.00	0.65	Waterjet 1		SR 18/10/18
120	QC	10 pcs		11/16/18	0.00	0.00	QC8		38
130	Brake NC	10 pcs		11/16/18	0.04	0.38	Brake NC 2		9-88 DAS SB
140	QC	10 pcs		11/16/18	0.00	0.00	QC5		38
150	HandFinish	10 pcs		11/16/18	0.00	0.34	HandFinish1		D.R. 18/10/18 30
160	QC	10 pcs		11/16/18	0.00	0.00	QC7-4		38
170	Packaging	10 pcs		11/16/18	0.00	0.00	Packaging3-2	DAS 21 9-88	7/10 9-88
180	QC21-SA	10 Ea		11/16/18	0.00	0.00	QC21		NOV 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.8750 sf (.0875 ea)	100-Waterjet	5099479

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.040	1	292	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.630Inches + 0.008 - 0.001	0.638 0.629	0,629 Diameter	
2	Bracket	2.350Inches ± 0.030	2.380 2.320	2,344	
3	Bracket	1.300Inches ± 0.010	1.310 1.290	1,298	
4	Bracket	1.800Inches ± 0.030	1.830 1.770	1,794	
5	Bracket	0.900Inches ± 0.030	0.930 0.870	0,897	
6	Bracket	0.500Inches ± 0.030	0.530 0.470	0,496	
7	Bracket	1.200Inches ± 0.030	1.230	1,201	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Sc ☐ Use ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐																																																																																																						
Date : _____ Step #: _____		MRB (QSI042) Approval _____																																																																																																						
Description Work Order Deviation Container No: S121111 Part: D4712-1 Job No: 185097 Serial No/ Batch: S121111 Revision: S121111 Inspector: S121111 Exp Date: S121111 Instructions: Various STC's Date: 10/24/18																																																																																																								
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> <th colspan="2" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:15%;">☐</td> <td style="width:15%;">No Re-verification</td> <td style="width:15%;">☐</td> <td style="width:15%;">Pressure/Forced</td> <td style="width:15%;">☐</td> <td style="width:15%;">Wrong</td> <td style="width:15%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td>Dimensions</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td>Centre Not Concentric</td> <td>☐</td> <td>der tolerance</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>orrect</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td>st/Missing</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Part Moved</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Turning Sequence</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td>OTHER :</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>					Root Cause		FAULT CATEGORY		Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Wrong	☐	Design	☐	Operator	☐	Bending	☐	Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	der tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	orrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	st/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐					Misidentified	☐	Past Due	☐	OTHER :			
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10	Bracket	5.000Inches $\pm$ 0.030	5.030 4.970	5,001
11	Bracket	0.221Inches + 0.006 - 0.001	0.227 0.220	0,221 Diameter
12	Bracket	0.129Inches $\pm$ 0.010	0.139 0.119	0,130
13	Bracket	6.000Inches $\pm$ 0.030	6.030 5.970	6,000
14	Bracket	0.040Inches $\pm$ 0.010	0.050 0.030	0,038

Plex 10/22/18 2:57 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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